

Del 1.25  
Work Order ID 80225

\*80225\*

Page 1

February-14-12 4:19:01 PM

Item ID: D3417-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Washer

Start Date: 14/02/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 28/02/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 12/02/14

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3417	Rev E								
100	DOOSAN LATHE	0.00				50	4		
*100*									
Doosan	Memo	0.00							
Doosan Lathe	1-Turn as per Folio FA594 Rev: _____ & Dwg D3417 Rev: _____ 2-Deburr								
				123127					
110	QC2- Inspect parts off machine FAI/FAIB	0.00				50	6		
*110*									
QC	Memo	0.00							
Quality Control				123127					
120	QC8- Inspect parts - second check	0.00				50	8		
*120*									
QC	Memo	0.00							
Quality Control				1210368					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80225

**\*80225\***

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February-14-12 4:19:01 PM

Item ID: D3417-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Washer  
 Start Date: 14/02/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 28/02/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>042</u>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

1143/28 (50)

12/3/29 *[Signature]*

*mc*

12-03-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

February-14-12 4:19:05 PM

Page 1

Work Order ID: 80225

\*80225\*

Parent Item: D3417-3

\*D3417-3\*

Parent Item Name: Washer

Start Date: 14/02/2012

Required Date: 28/02/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A05.10.19New issueKJ/EC  
IPP Rev:B05.10.19added haas op. EC  
IPP Rev:C As per Rev D 08-07-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDEL RINR1.2500

Purchased

No

100

f

16.5320

0.0296

0.623158

\*MDFI RINR1 2500\*

\*\*

DELRIN ROUND BAR 1.25"

1203128

Location

Loc Qty

Loc Code

MAT055

16.532

114586

1.449

119133

15.083

281

W/O:		WORK ORDER CHANGES					
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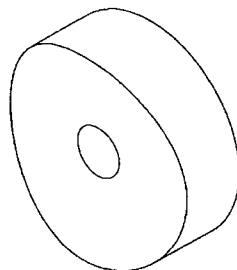
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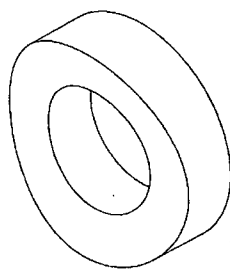
**NOTE:** Date & initial all entries



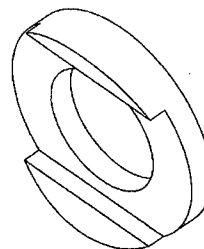
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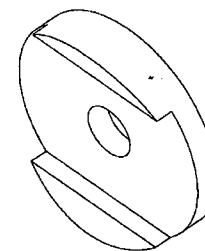
D3417-1 WASHER



D3417-3 WASHER



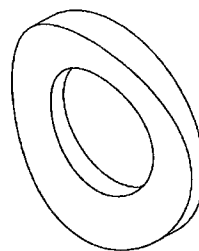
D3417-5 WASHER



D3417-7 WASHER

SHOWN  
REF  
FROM  
UNCONTROLLED  
SUBJECT TO

WT  
WOL  
NO 80225 M.L.J  
12/02/14



D3417-9 WASHER

**RELEASED**  
2010-09-15

**NOTES:**

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD  
REF DART SPEC M-DELIN-R  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR  
REF DART SPEC M-DELIN-B  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET  
REF DART SPEC M-DELIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs  
D3417-3, 0.010 lbs  
D3417-5, 0.010 lbs  
D3417-7, 0.010 lbs  
D3417-9, 0.004 lbs

F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.08.30
D	ADD -S WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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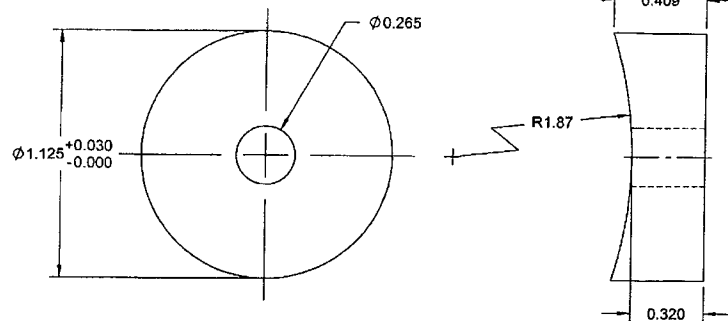
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

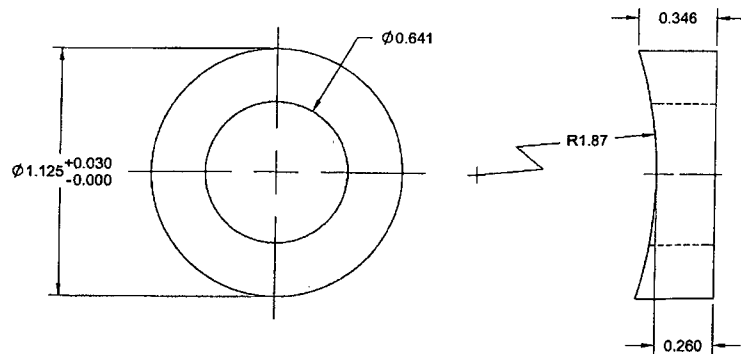
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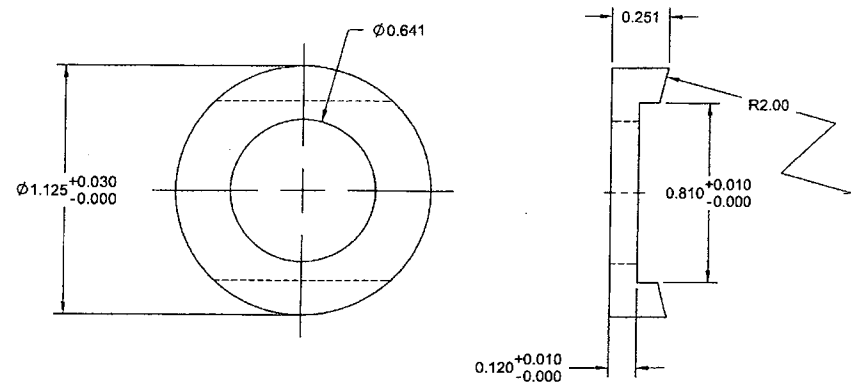
80225



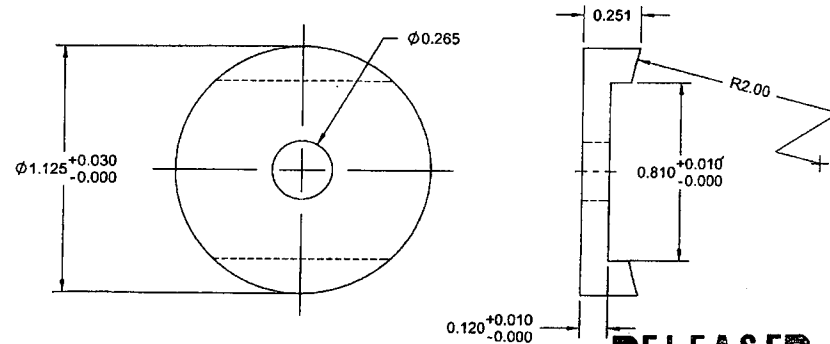
**D3417-1 WASHER**



**D3417-3 WASHER**



**D3417-5 WASHER**



**D3417-7 WASHER**

**RELEASED**  
2010-09-15

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MFG. APPR.		TITLE <b>WASHER</b>	SHEET 2 OF 3
APPROVED			SCALE NTS
DE APPR.			
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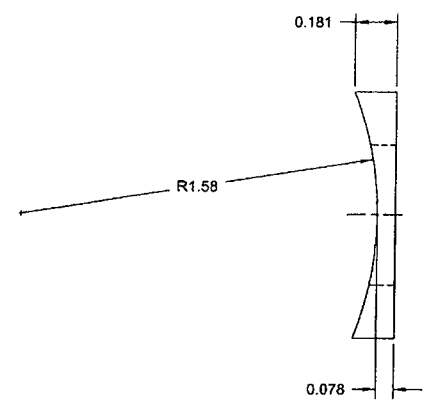
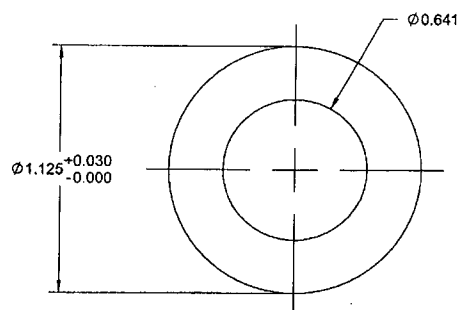
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80225



D3417-9 WASHER



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2010-09-15

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CHECKED	JS	DRAWING NO.	REV. F
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APPROVED		TITLE	SCALE
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